



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Sprint

D3488-042
Job Sheet 167599



Part No: **D3488-042**

Job Qty: 6 ea

Part Name: Blade Fitting RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/3/17

Job Tracking No:

Due Date: 11/17/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		11/16/17	0.00	0.00	Start Up Machining		<i>18/02/14</i>
100	Doosan	6 pcs		11/16/17	0.00	5.27	Doosan		<i>18/02/14</i>
110	QC	6 pcs		11/16/17	0.00	0.00	QC2		<i>18/02/14</i>
120	CNC Vertical Machining	6 pcs		11/16/17	0.11	4.11	HAAS 1		<i>18/02/16</i>
130	QC	6 pcs		11/16/17	0.00	0.00	QC2		<i>18/02/16</i>
140	QC	6 pcs		11/16/17	0.00	0.00	QC8		<i>18-03-06</i>
150	HandFinish	6 pcs		11/16/17	0.00	0.18	HandFinish1		<i>18-03-06</i>
160	Powdercoat	6 pcs		11/17/17	0.00	0.21	Powdercoat1		<i>18-03-07</i>
170	QC	6 pcs		11/17/17	0.00	0.00	QC3		<i>18-03-07</i>
180	HandFinish	6 pcs		11/17/17	0.00	0.00	HandFinish4		<i>18-03-07</i>
190	QC	6 pcs		11/17/17	0.00	0.00	QC5		<i>18-03-07</i>
200	Packaging	6 pcs		11/17/17	0.00	0.00	Packaging3	<i>FP001</i>	<i>18-03-07</i>
210	QC21-SA	6 Ea		11/17/17	0.00	0.00	QC21		<i>18-03-07</i>

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625

Descriptions: 120 - 1-Machine as per Folio FA627 & Dwg D3488

160 - START TIME: *1130pm To 2100pm 3200*

180 - Install Inserts as per Dwg D3488

200 - LOCATION : FP001

21
9:00 MAR 08 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6103-003	6	12	0	0
180-HandFinish	ALS7-1032-225 <i>5007290</i>	24	116	0	0

Part Specifications

Specifications could not be found.

Plex 11/3/17 8:37 AM dart.Michaud-Febrille.Victoria

DART
AEROSPACE

S007379



Blade Fitting RH

PART NO: D3488 - 042

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/07/17

Job No: 167599

Dart Aerospace Ltd.

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CANADA

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DART AEROSPACE LTD		Work Order:	
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.148	✓			
Ø2.780	+/-0.005	2.780	✓			
Ø3.125	+/-0.010	3.124	✓			
Ø3.346	+/-0.010	3.345	✓			
0.125 x 45°	+/-0.010 x +/-0.1°	0.123 x 45°	✓		Dowell Pin	
8.000	+0.030/-0.000	8.017	✓			
9.250	+/-0.010	9.250	✓			
0.188	+/-0.010	0.188	✓		height gage	
R0.032	+/-0.010	0.032	✓		RG	
R0.062	+/-0.010	0.062	✓		RG	
Ø0.297	+0.005/-0.001	0.298	✓			
Ø0.430	+/-0.010	0.432	✓		Dowell Pin	
0.100	+/-0.010	0.098	✓			
0.125	+/-0.010	0.127	✓		Vernier	
2.620	+/-0.010	2.610	✓			
3.500	+/-0.010	3.500	✓			
1.005	+/-0.010	1.0055	✓			
Ø0.484	+0.005/-0.001	0.487	✓		Dowell Pin	
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.062	✓		height gage	
R0.063	+/-0.010	0.0635	✓		RG	

DART AEROSPACE LTD	Work Order:	
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	0.508	✓		Dowell Pin	
0.750	+/-0.010	0.777	✓		height gage	
1.500	+/-0.010	1.492	✓			
11.18	+/-0.030	11.18	✓			
R0.062	+/-0.010	R0.062	✓		RG	
0.125	+/-0.010	0.127	✓		Vernier 148-01	
0.590	+/-0.010	0.580	✓		height gage	
0.793	+/-0.010	0.798	✓			
1.351	+/-0.010	1.353	✓			
1.317	+/-0.010	1.323	✓			
1.802	+/-0.010	1.797	✓			

Measured by:	DAS 23 9-89	Audited by:		Prototype Approval:	N/A
Date:	17/11/07	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	

A: _____ Date: _____

Closed: 2R Date: SEP 16 2020

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>167599</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3488-042</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>20-8458</u>		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			
e: <u>18-02-16</u>	Step #: <u>120</u>	QTY Effective: <u>2 3</u>				MRB (QS1042) Approval DAS 55 9-89 JUL 02 2020	

Description Work Order Deviation → operator crashed the edge finder to take origin on part in part → 1st part → operator installed the part on the opposite side of fixture resulting as the 97° angle is oriented (reversed)	Disposition → scrap n destroy (no replace)	Completed By 18/2/16 Lead hand / Supervisor Approval Verification 18-02-16 QC / QA Coordinator DAS Approval 55 9-89 JUL 02 2020
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☒	Positioned Wrong ☒		
Design ☒	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☒	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Technical Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Fast Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					